

1. An injection mold inner core die comprising:
a window mold member projecting from a surface of the inner core die and
configured to define a window in an interior wall of a piece being molded by the die,
wherein the window mold member is configured to separate the interior wall of the piece
5 being molded from the surface when the molded piece and inner core die are separated.

2. The injection mold inner core die, as in claim 1, wherein the window mold
member has a flat top.

10 3. The injection mold inner core die, as in claim 1, wherein the window mold
member comprises a pair of ramps which slope outwardly from the surface of the inner
core die.

15 4. The injection mold inner core die, as in claim 3, wherein the ramps are
generally parallel.

5. The injection mold inner core die, as in claim 3, wherein the ramps run
from the surface to a flat top.

20 6. The injection mold inner core die, as in claim 1, wherein the window mold
member is made of metal.

7. The injection mold inner core die, as in claim 1, wherein the pair of ramps
are located on an end of the window mold member which is opposite a direction of
25 motion of the piece being molded with respect to the inner core die when the molded
piece is separated from the inner core die.

8. The injection mold inner core die, as in claim 1, wherein the window mold member comprises a boss disposed between the ramps to facilitate separation of the interior wall from the surface.

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9. The injection mold inner core die, as in claim 8, wherein the boss is configured as a half-sphere attached to the surface.

10. The injection mold inner core die, as in claim 8, wherein the boss is positioned between parallel ramps.

11. The injection mold inner core die, as in claim 8, wherein the boss is configured as an incline plane.

12. The injection mold inner core die, as in claim 1, further comprising a plurality of window mold members configured to form a plurality of windows.

13. An injection mold inner core die comprising:
a window mold member projecting from a surface of the inner core die and configured to define a window in an interior wall of a piece being molded by the die, wherein the window mold member is configured with at least two parallel ramps connected to the window mold member

14. The injection mold inner core die, as in claim 13, wherein the window mold member has a flat top.

15. The injection mold inner core die, as in claim 14, wherein the ramps run from the surface to the flat top.

16. The injection mold inner core die, as in claim 13, further comprising a
5 boss positioned between the ramps.

17. The injection mold inner core die, as in claim 13, wherein the inner core die has inverted corners.

10 18. The injection mold inner core die, as in claim 13, wherein the inner core die is rectangular in shape.

19. The injection mold inner core die, as in claim 13, wherein a plurality of window mold members are disposed on the surface.

15 20. An airbag injection mold inner core die, comprising:
a back connected to an injection mold;

a front,

one or more sides to connect the front to the back,

20 a window mold member disposed on a side and configured to form a window within a wall of a molded airbag cover; and

a pair of ramps connected to the window mold member and configured to slope from the front toward the back.

21. An airbag injection mold inner core die, as in claim 20, further comprising a plurality of window mold members disposed on each side.

5 22. An airbag injection mold inner core die, as in claim 21, further comprising a boss connected to the side and positioned between the ramps.

23. An airbag injection mold inner core die, as in claim 22, wherein one side meets another to form a concave corner.

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24. A method for fabricating an airbag cover comprising openings disposed within an interior wall, comprising:

providing an airbag injection mold comprising an inner core die configured with a front connected to four sides which are connected to a back, wherein one or more window mold members are disposed on the sides, and wherein the window mold members comprise a pair of ramps and a boss connected to the window mold members at a point closest to the back;

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injecting a liquid airbag cover material into the mold;

cooling the liquid airbag cover material to form a pliable rigid airbag cover;

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raising the inner core die from an outer core die such that the airbag cover remains secured to the inner core die;

separating the airbag cover from the inner core die.

25. A method as in claim 24, wherein separating comprises holding the inner core stationary while moving the airbag cover away from the inner core.

26. A method as in claim 24, wherein separating comprises moving the inner
5 core in a first direction while moving the airbag cover in a second direction.

27. A method as in claim 24, wherein the four sides connect to each other to form inverted corners.

10 28. A method as in claim 24, wherein the inner core is rectangular shaped.